

Date: Thursday, 15/01/2009 8:34:42 AM
 User: Julie Dawson

Process Sheet

| | |
|---|--|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : RIB ASSY (BASKET LID, LH) |
| Job Number : 44772 | |
| Estimate Number : 13665 | |
| P.O. Number : | Part Number : D3838041 |
| This Issue : 15/01/2009 S.O. No. : | Drawing Number : D3838 REV A |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : / / Type : LARGE FAB ASSY | Drawing Revision : A |
| Previous Run : 44020 | Material : |
| Written By : | Due Date : 22/01/2009 Qty: 2 Um: Each |
| Checked & Approved By : <u>JUD 09.01.15</u> | |
| Comment : Est Rev:A 08-12-01 new issue DD verified by:EC | |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|----------------|---------------------------|
| 1.0 | M304TS0750W065 | 304 SQ Tube .75x.75x.065W |
|-----|----------------|---------------------------|



Comment: Qty.: 1.0833 f(s)/Unit Total : 2.1666 f(s)

304 SQ Tube .75x.75x.065W

batch: 2110011

SAD

09-01-21

| | | |
|-----|-------------|------------------------------|
| 2.0 | LARGE FAB 1 | LARGE FABRICATION RESOURCE 1 |
|-----|-------------|------------------------------|



Comment: LARGE FABRICATION RESOURCE 1

1- cut D3838-1 and D3838-3 rib as per dwg D3838

holes
 drilled
 at
 station 5.1

2- c/sink hole as per dwg A/n

3- remove identification markings

4- deburr

SAD 09-01-21

| | | |
|-----|-----|------------------------------|
| 3.0 | QC5 | INSPECT WORK TO CURRENT STEP |
|-----|-----|------------------------------|



Comment: INSPECT WORK TO CURRENT STEP

SAD 09-01-21 (421H)

| | | |
|-----|--------|---------|
| 4.0 | D37591 | Bushing |
|-----|--------|---------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bushing

batch: 344717v

P 09-01-21

| | | |
|-----|-------------|------------------------------|
| 5.0 | LARGE FAB 1 | LARGE FABRICATION RESOURCE 1 |
|-----|-------------|------------------------------|



Comment: LARGE FABRICATION RESOURCE 1

1- weld D3838-1 to D3838-3 and drill hole (3/16") using DT9437 jig and open to finish size as per dwg D3838

A/R ER316 S.S. Rod Batch: m106762

P 09-01-21

(2)

| W/O: | | WORK ORDER CHANGES | | | | | | | |
|------|------|--------------------|--|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | | | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | | | |
| | | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|--|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector | |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | | |
| | | | | | | | | | |
| | | | | | | | | | |
| | | | | | | | | | |

NOTE: Date & initial all entries

Date: Thursday, 15/01/2009 8:34:42 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RIB ASSY (BASKET LID, LH)

Job Number: 44772

Part Number: D3838041

Job Number:



Seq. #:

Machine Or Operation:

Description :

- 2- grind weld flush where indicated on dwg D3838
- 3- weld D3759-1 bushing as per dwg D3838
- 4- grind bushing weld flush as per dwg dwg D3838
- 5- deburr hole if necessary

Pl 09.01.21

6.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 09.01.22 (2)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09.01.22 (2) 4H

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Basket c.

PD 09.01.22 (2)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/22 (2)

Job Completion



U 09.01.22

| W/O: | | WORK ORDER CHANGES | | | | | | | |
|------|------|--------------------|--|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | | | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | | | |
| | | | | | | | | | |

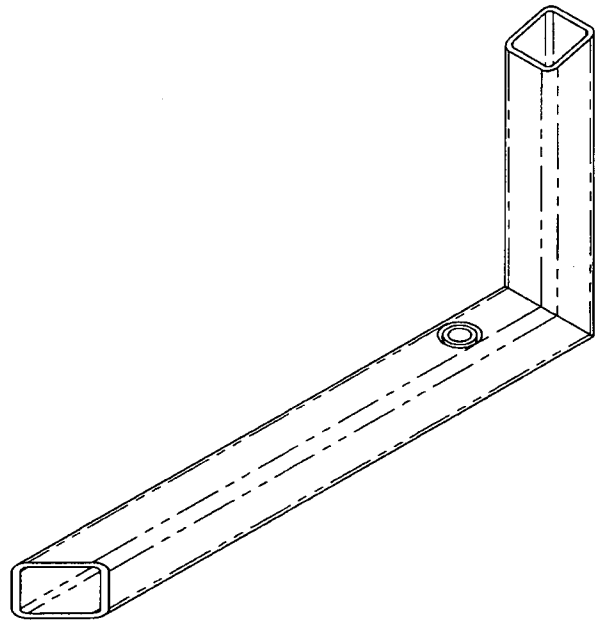
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

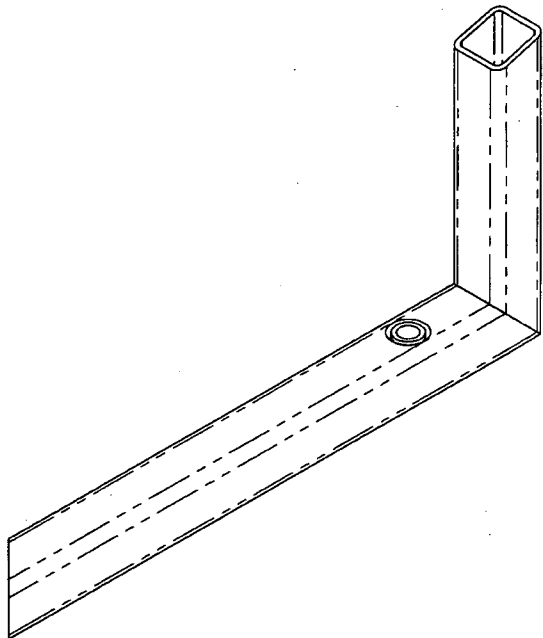
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|--|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector | |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | | |
| | | | | | | | | | |
| | | | | | | | | | |
| | | | | | | | | | |

NOTE: Date & initial all entries

| ITEM | QTY -041 | QTY -042 | P/N | DESCRIPTION |
|------|-------------|-------------|-----------|---------------------------|
| 1 | X | | D3838-041 | RIB ASSY (BASKET LID, LH) |
| 2 | | X | D3838-042 | RIB ASSY (BASKET LID, RH) |
| 3 | 1 | 1 | D3759-1 | BUSHING |
| 4 | 1 | | D3838-1 | RIB |
| 5 | | 1 | D3838-2 | RIB |
| 6 | 1 | 1 | D3838-3 | RIB |



D3838-041 RIB ASSY (BASKET LID, LH)



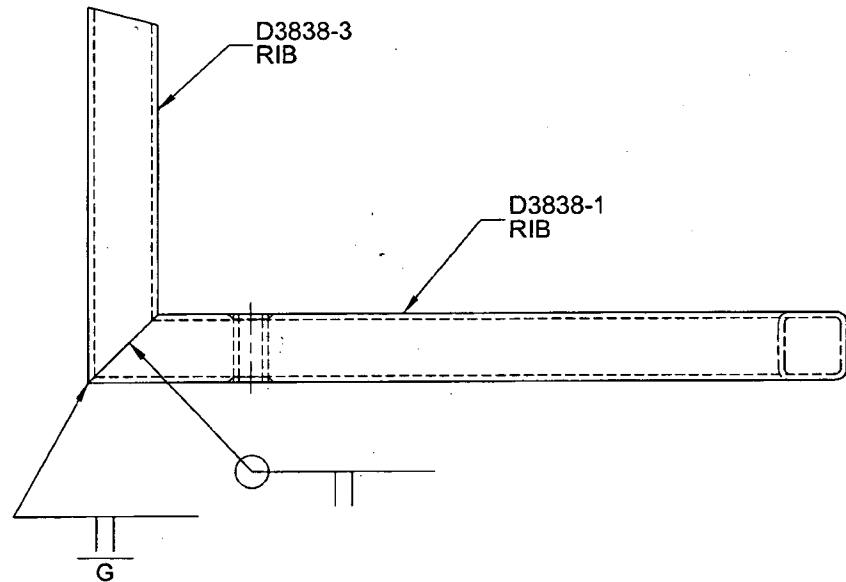
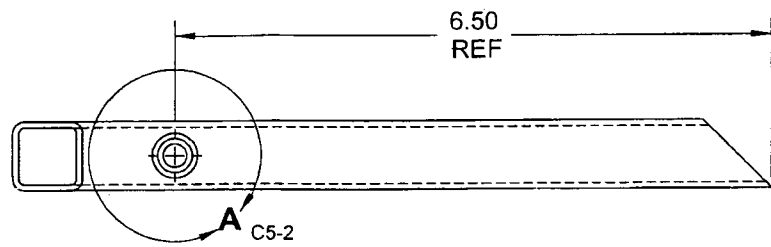
D3838-042 RIB ASSY (BASKET LID, RH)

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 44772

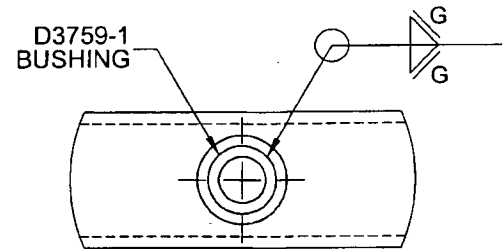
RELEASED
08/11/08

NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.54 lbs

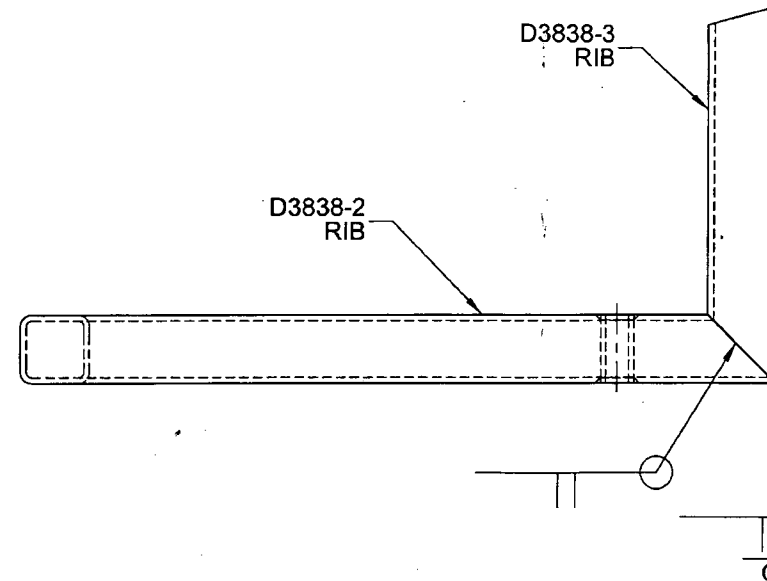
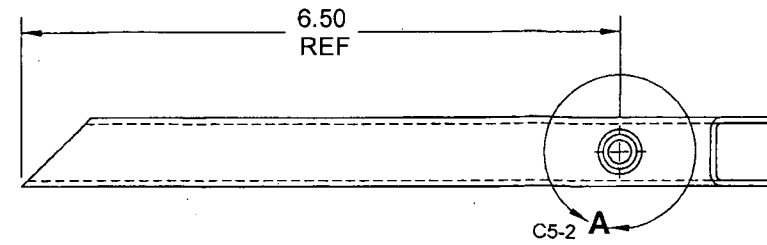
| | | | |
|------------|-------------|---|--------------|
| A | NEW ISSUE | MB | 08.10.08 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. A |
| MFG. APPR. | | D3838 | SHEET 1 OF 3 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | RIB ASSY (BASKET LID) | NTS |
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D3838-041 RIB ASSY (BASKET LID, LH)



DETAIL A
D2-2
D7-2 SCALE 2X

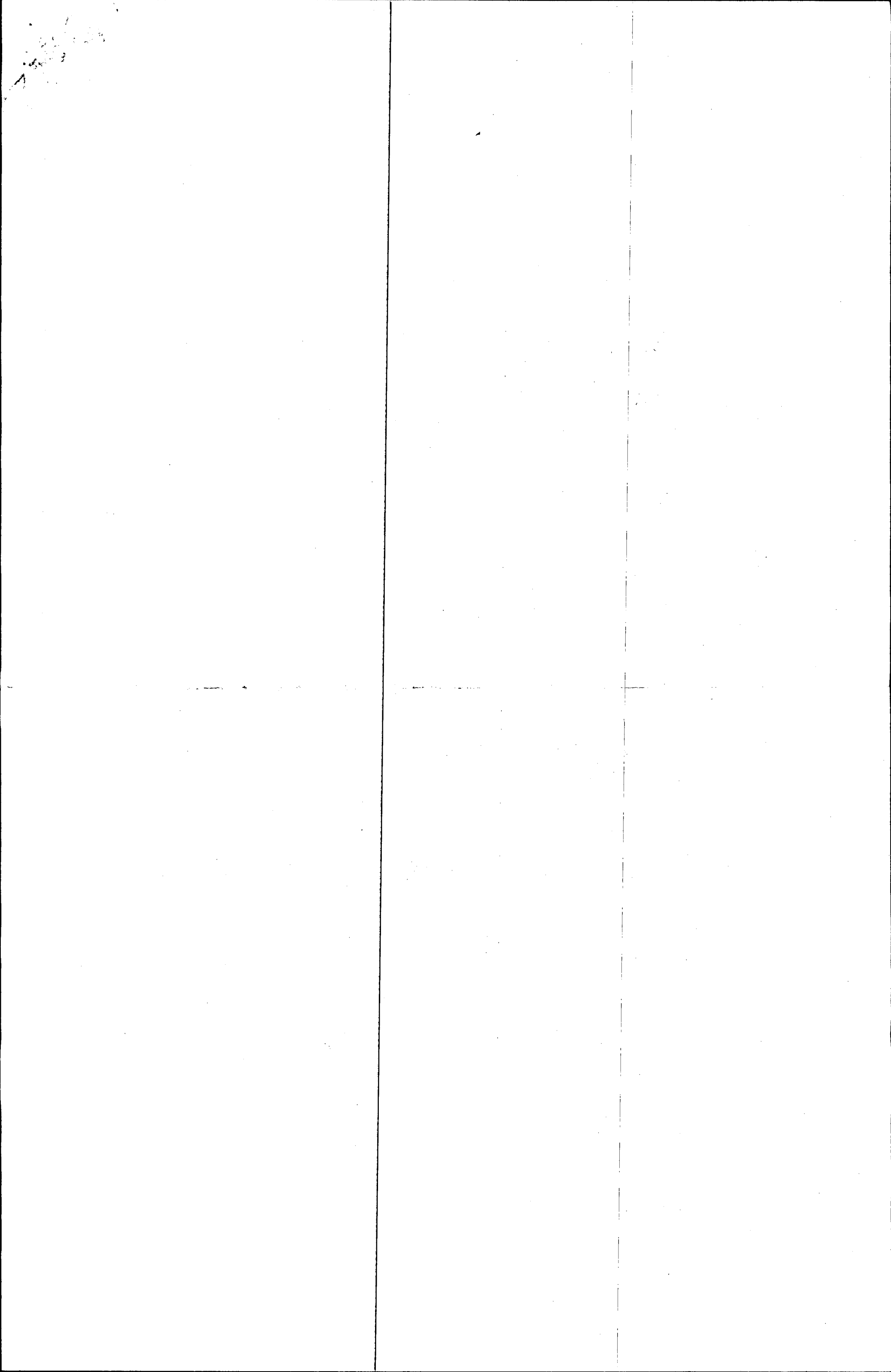


D3838-042 RIB ASSY (BASKET LID, LH)

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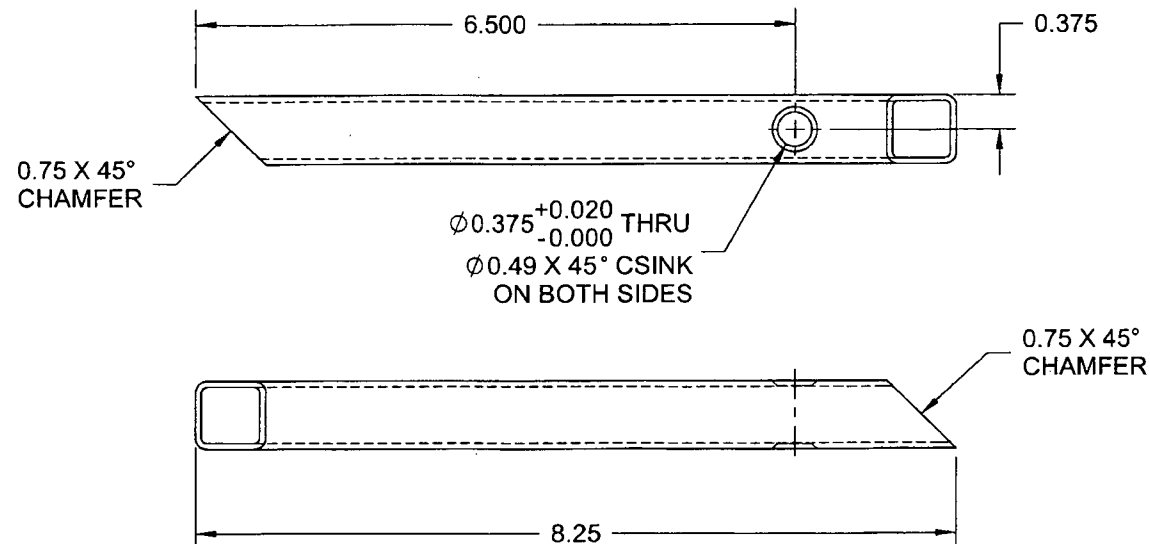
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| CHECKED | | DRAWING NO. | REV. A |
| MFG. APPR. | | D3838 | SHEET 2 OF 3 |
| APPROVED | | TITLE | SCALE |
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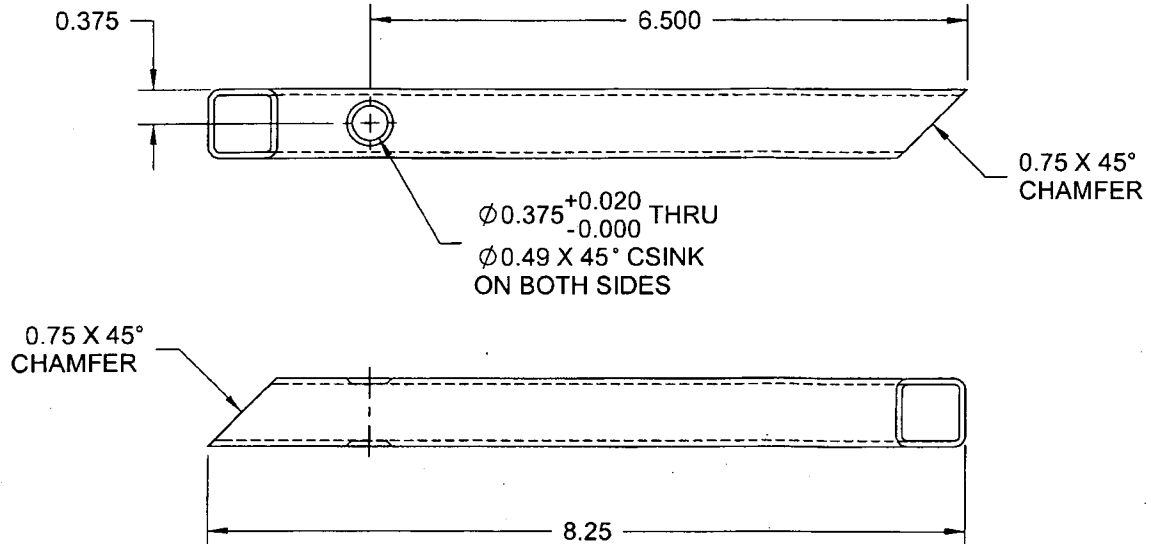


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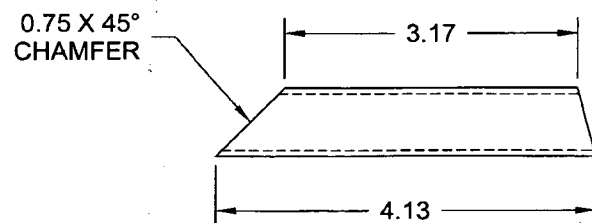
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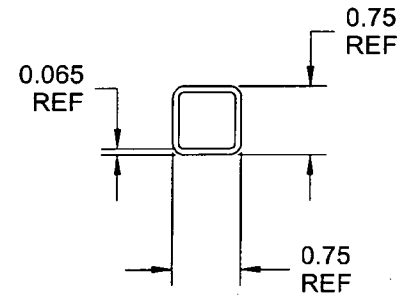
D3838-1 RIB



D3838-2 RIB



D3838-3 RIB



TYPICAL SECTION VIEW

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 44772

RELEASED

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3836-1/2 = 0.35 lbs EACH; D3836-3 = 0.19 lbs

| | | | |
|------------|--------------------|---|--------------|
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| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | <i>[Signature]</i> | DRAWING NO. | REV. A |
| MFG. APPR. | <i>[Signature]</i> | D3838 | SHEET 3 OF 3 |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
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8 7 6 5 4 3 2 1

